

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004689**Date Inspected:** 21-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Heavy Tower Shop II

QA was tasked by others to observe and photographically document the lifting & moving of the south tower shaft. This process took approximately 45 minutes for the piece to be brought from the east side of the shop to the middle or western side. See the photographs below for further details.

OBG Assembly Bay II

5AE- QA performed informal green tagging with the AB/F/ ZPMC/ Caltrans Tagging Team on Deck Panels DP297-001, DP405-001, DP459-001, DP378-001. Deck Panel 324-001 was requested to be tagged but denied green tagging due to an outstanding Non Conformance Report for making weld repairs on U-Rib to deck panel joints without prior approval from the Engineer which was reported to QA by Caltrans representative Charles Ho.

5BE- QA performed informal green tagging with the AB/F/ ZPMC/ Caltrans Tagging Team on Deck Panels DP325-001 & DP487-001

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5CE- QA performed informal green tagging with the AB/F/ ZPMC/ Caltrans Tagging Team on Deck Panels DP580-001, DP326-001, DP353-001, DP488-001 & DP299-001

3AE- No QA Observed Welding Activity

3BE- No QA Observed Welding Activity

4AE- No QA Observed Welding Activity

4BE- No QA Observed Welding Activity

Mid bay-

Diaphragm plate to deck panel joining/ tacking at DP297-001, DP487-001.

NPI of Oregon continues to perform evaluations utilizing the phased array ultrasonic testing method for locations and sizing of partial penetration weld and associated cracks for acceptance in the deck panel to U-rib locations.

5CW- QA performed informal green tagging with the AB/F/ ZPMC/ Caltrans Tagging Team on Deck Panel DP191-001

5BW- QA performed informal green tagging with the AB/F/ ZPMC/ Caltrans Tagging Team on Deck Panel DP109-002

5AW- No QA Observed Welding Activity

4BW- No QA Observed Welding Activity

4AW- No QA Observed Welding Activity

3BW- No QA Observed Welding Activity

3AW- No QA Observed Welding Activity

North Bay of OBG Assembly- No QA Observed Welding Activity

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Summary of Conversations:

No relevant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dauterman, who represents the Office of Structural Materials for your project.

Inspected By: Vatcher,Robert

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer